

# Work Order ID 109368

Thursday, November 21, 2013 9:04:15 AM

\*109368\*

Page 1

Item ID: D3937-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Photo Luminescent Strip

Stop \*NS2\*

Start Date: 11/21/2013 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 11/21/2013 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 13-11-21

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3937	B								
100		0.00							
<b>*100*</b>									
Shear	Memo	0.00							
Shear	1-Cut as per Dwg D3937 (Make D3937-3) Dwg Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

DAS  
30  
9-89

*FF*  
13-11-21

13/11/21

*FF*  
13-11-21

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Thursday, November 21, 2013 9:04:15 AM

**\*109368\***

Page 2

Item ID: D3937-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Photo Luminescent Strip

Stop **\*NS2\***

Start Date: 11/21/2013 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 11/21/2013 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC7-Inspect Chemical Conversion Coat

0.00

**\*140\***

QC

Memo

0.00

Quality Control

DAS  
30  
9-89

2

13/11/21

150

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

1- Align part edges and stick strip to D3937-3 as per dwg

DAS  
27  
9-89

2

FF  
13-11-21

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

13/11/21

2

**Work Order ID 109368**

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**\*109368\***

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Item ID: D3937-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Photo Luminescent Strip

Start Date: 11/21/2013 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 11/21/2013 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Memo

SHIP

0.00

Packaging

P43/11/21 (2)

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

WFC 13-11-21

13-11-21

# Picklist Print

Thursday, November 21, 2013 9:04:14 AM

Page 1

Work Order ID: 109368  
 Parent Item: D3937-041  
 Parent Item Name: Photo Luminescent Strip

Start Date: 11/21/2013

Required Date: 11/21/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3937-1 Luminescent Strip		Manufactured	No				Each	18.0000		2		FF 13-11-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST074		18							
				107121		18			2				
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	563.9160	0.09099	1		FF 13-11-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		563.916							
				123483		256.15							
				m125822		48.1							
				m126115		60.356							
				m126309		55.31			2				
				m127272		144							

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

PEEL SELF-ADHESIVE BACKING FROM  
D3937-1 LUMINESCENT STRIP,  
ALIGN PART EDGES AND STICK TO  
D3937-3 SHEET METAL BACKING STRIP

# D3937-041 LUMINESCENT STRIP ASSEMBLY

#109368

RELEASED  
2009-12-02

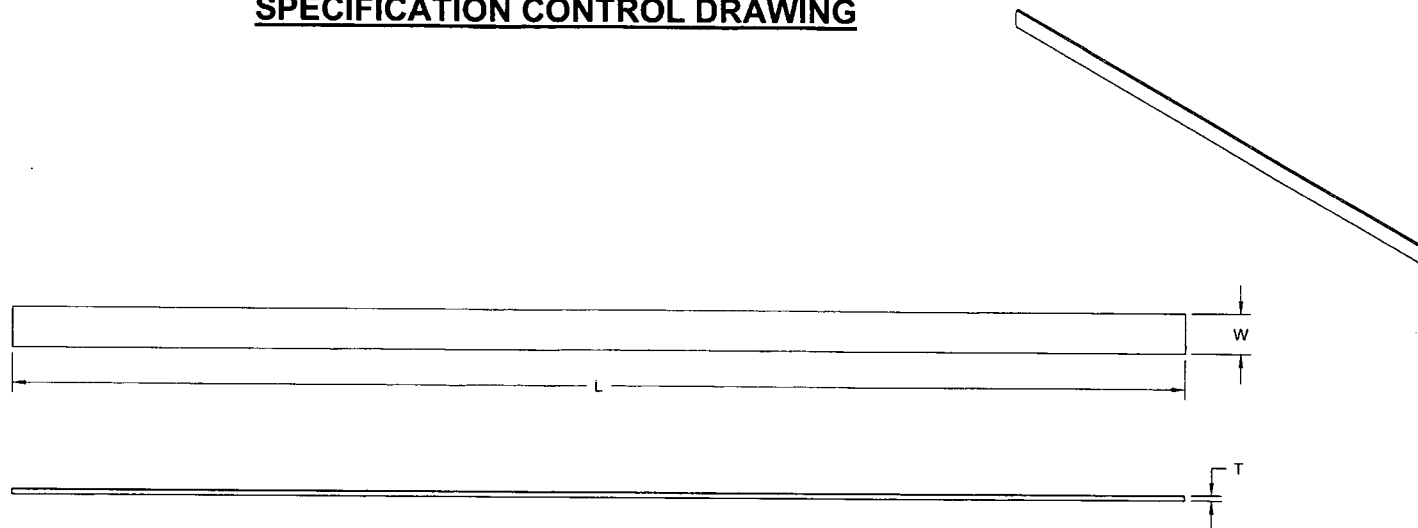
B	SHEET 2 SPEC CHART LENGTH WAS 21.0. SHEET 3 ZONE C5 19.5 DIM WAS 21.0 REASON: PREVENT EXCESSIVE WASTE.		AJS	09.11.27
A	NEW ISSUE		BY	09.06.02
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DRAWING NO.	REV. B
CHECKED	AJS		D3937	SHEET 1 OF 3
MFG. APPR.	AJS		TITLE	SCALE
APPROVED	AJS		LUMINESCENT STRIP	NTS
DE APPR.	AJS		DATE 09.11.27	
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## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs



# SPECIFICATION CONTROL DRAWING



## D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	19.5	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS

△B

### NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE TABLE

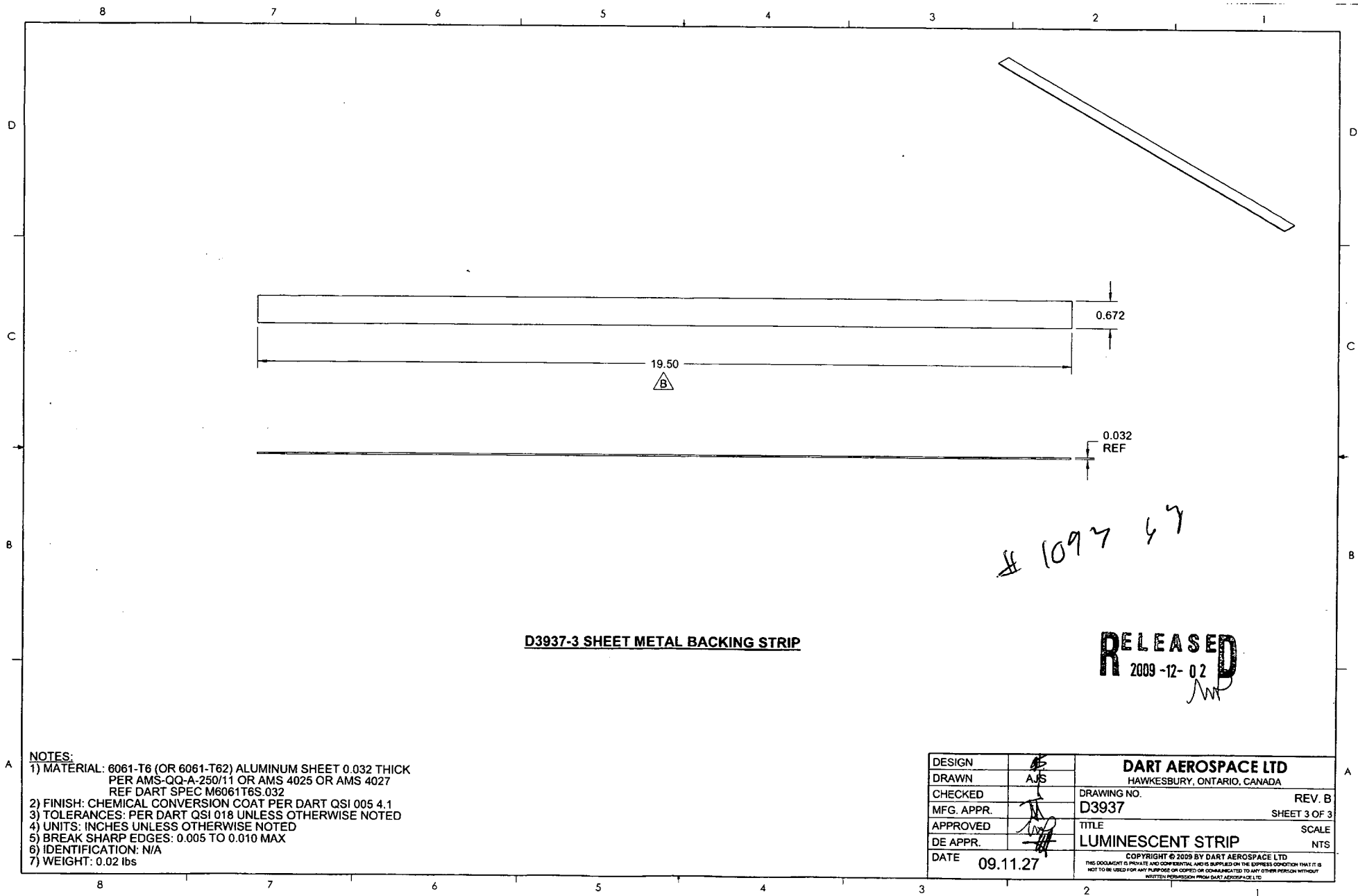
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3937	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
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#109368

**RELEASED**  
2009-12-02







**D3937-3 SHEET METAL BACKING STRIP**

# 1097 47

**RELEASED**  
2009-12-02

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3937	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
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13.11.21

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